

Date: Thursday, 4/12/2007 8:44:47 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number	: 31714		
Estimate Number	: 10531		
P.O. Number	: <u>N/A</u>	Part Number	: D2572
This Issue	: 4/12/2007	S.O. No.	: <u>N/A</u>
Prsht Rev.	: <u>NC</u>	Drawing Number	: D2572 REV E
First Issue	: <u>N/A</u>	Project Number	: N/A
Previous Run	: 31648	Drawing Revision	: E
		Material	: <u>N/A</u>
		Due Date	: 4/30/2007
Written By	: <u>JA 07.04.12</u>	Qty:	12
Checked & Approved By	: <u>JA 07.04.12</u>	Um:	Each
Comment	: Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	7075-T7351 8.25X5.0X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
 7075-T7351 8.25X5.0X2.5
 Make from D6101-005 billet for D2572
 Ensure that grain is along 5.00" length
 Batch No: 25352

MS 07/04/25 12

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. 31714 Double check by: JL

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
 4-Deburr and remove all machining marks
 5-Tumble to remove shap edges.

EP/MS 07/04/25

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2571 & D2572

MS/EP 07/05/03

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS/EP 07/05/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:44:47 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 07/05/03

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

F2L

07/05/03.

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SL

07-05-07 (12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

SL 07/05/08 (12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

SL 07/05/08 (12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SL 07/05/08 (12)

Job Completion



SL 07/05/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31714
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.747	1.749	1.747	1.750		
C	3.495	3.505		3.499	3.500	3.500	3.500		
D	1.745	1.755		1.747	1.749	1.747	1.747		
E	7.990	8.010		8.003	8.002	8.002	8.001		
F	0.490	0.510		0.496	0.497	0.500	0.500		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.495	0.497	0.499	0.499		
J	1.174	1.184		1.175	1.175	1.177	1.177		
K	0.558	0.578		0.565	0.566	0.563	0.563		
L	1.174	1.184		1.175	1.175	1.177	1.177		
M	1.490	1.500		1.495	1.495	1.492	1.493		
N	2.495	2.505		2.500	2.498	2.498	2.498		
O	3.869	3.879		3.872	3.871	3.872	3.872		
P	0.115	0.135		0.123	0.123	0.124	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.253	0.253	0.252	0.252		
S	0.115	0.135		0.126	0.124	0.123	0.123		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.237	0.237	0.237	0.237		
W	0.115	0.135		0.127	0.127	0.130	0.130		
X	0.307	0.312		0.311	0.311	0.311	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.365	0.366	0.360	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.625	0.627	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.250	0.250	0.250		
AE	1.375	1.395		1.386	1.385	1.384	1.384		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.250	0.251	0.251		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	Er
Date:	02/01/26

Audited by:	JL
Date:	07/05/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	31714
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

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				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.747	1.749	1.746	1.748		
C	3.495	3.505		3.500	3.498	3.500	3.500		
D	1.745	1.755		1.750	1.749	1.746	1.748		
E	7.990	8.010		8.001	8.002	8.002	8.003		
F	0.490	0.510		0.501	0.497	0.496	0.494		
G	0.257	0.262	DT8683	0.258	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.376	0.377	0.377	0.377		
I	0.490	0.510		0.500	0.498	0.499	0.498		
J	1.174	1.184		1.177	1.177	1.177	1.178		
K	0.558	0.578		0.568	0.563	0.565	0.566		
L	1.174	1.184		1.176	1.177	1.177	1.178		
M	1.490	1.500		1.495	1.492	1.493	1.493		
N	2.495	2.505		2.500	2.498	2.499	2.499		
O	3.869	3.879		3.872	3.871	3.871	3.871		
P	0.115	0.135		0.123	0.122	0.123	0.123		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.253	0.252	0.251	0.252		
S	0.115	0.135		0.126	0.125	0.123	0.125		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.237	0.237	0.237	0.238		
W	0.115	0.135		0.127	0.130	0.125	0.126		
X	0.307	0.312		0.310	0.310	0.311	0.311		
Y	0.760	0.765		0.762	0.765	0.765	0.765		
Z	0.352	0.372		0.365	0.360	0.362	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.626	0.626	0.626		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.251	0.251	0.250		
AE	1.375	1.395		1.384	1.385	1.385	1.386		
AF	0.115	0.135		0.125	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.251	0.247	0.248		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.032	0.033	0.033	0.033		
Accept/Reject									

Measured by:	EN / MS
Date:	07/04/30

Audited by:	J.L
Date:	07/05/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	31714
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

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B	1.745	1.755		1.746	1.746	1.746	1.750		
C	3.495	3.505		3.499	3.498	3.501	3.499		
D	1.745	1.755		1.746	1.746	1.748	1.750		
E	7.990	8.010		8.002	8.003	8.003	8.004		
F	0.490	0.510		0.501	0.499	0.492	0.485		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.497	0.496	0.494	0.498		
J	1.174	1.184		1.176	1.177	1.177	1.175		
K	0.558	0.578		0.566	0.567	0.567	0.566		
L	1.174	1.184		1.176	1.177	1.177	1.175		
M	1.490	1.500		1.494	1.494	1.495	1.484		
N	2.495	2.505		2.495	2.497	2.497	2.497		
O	3.869	3.879		3.870	3.872	3.872	3.872		
P	0.115	0.135		0.123	0.123	0.127	0.122		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.254	0.254	0.253	0.252		
S	0.115	0.135		0.125	0.126	0.122	0.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.238	0.236	0.235	0.235		
W	0.115	0.135		0.129	0.128	0.131	0.132		
X	0.307	0.312		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.362	0.362	0.362	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.625	0.625	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.251	0.251	0.250	0.252		
AE	1.375	1.395		1.385	1.386	1.385	1.385		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.249	0.248	0.247	0.248		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	En
Date:	07/05/03

Audited by:	J.L
Date:	07/05/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

05.12.06






1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010

2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)

3 CHAMFER 0.063 x 45° ALL AROUND

4 CHAMFER 0.033 x 45° (SEE DETAIL C) E



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4	
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES	
C	99.10.22	INCRP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177	
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425	
A	96.09.16	NEW ISSUE	
DESIGN		DRAWN BY	
DS		PH	
CHECKED 		APPROVED 	
		 DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA	
DATE		DRAWING NO.	
05.07.13		D2572	
		TITLE	
		INNER FWD SADDLE	
		SHEET OF	
		SCALE 2	

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